



CEWELD E Alloy C-276

TYPE	Stick electrode for welding NiCrMo alloys such as Hastelloy C-276. (Type Ni 6276, E NiCrMo-4)																							
APPLICATIONS	<p>CEWELD® E Alloy C-276 is used for welding materials of similar composition. This low carbon Nickel-Chromium-Molybdenum filler metal can also be used for dissimilar welding between nickel base alloys and stainless steels, as well as for surfacing and cladding on low alloyed steels. Applications include pumps, valves, pipelines and tanks in chemical processing plants, flue gas desulphurization plants and in the offshore oil and gas industry. The simple slag removal reduces the cleaning effort after welding to a minimum.</p>																							
PROPERTIES	<p>Thanks to its high molybdenum content, CEWELD® E Alloy C-276 offers excellent resistance to stress corrosion cracking, pitting and crevice corrosion. It also has high mechanical properties with excellent weldability with DC+. The easy slag removal reduces the cleaning effort after welding to a minimum.</p>																							
CLASSIFICATION	<table><tr><td>AWS</td><td>A 5.11: E NiCrMo-4</td></tr><tr><td>EN ISO</td><td>14172: E Ni 6276</td></tr><tr><td>W.Nr.</td><td>2.4886</td></tr><tr><td>F-nr</td><td>43</td></tr><tr><td>FM</td><td>6</td></tr></table>								AWS	A 5.11: E NiCrMo-4	EN ISO	14172: E Ni 6276	W.Nr.	2.4886	F-nr	43	FM	6						
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SUITABLE FOR	<p>Alloy 276, Ni 6276 (NiCr15Mo16Fe6W4). 2.4886, 2.4887 M.No: 1.5680, 1.5682, 2.4819, 2.4883 NiMo16Cr15W, X12Ni5 / 12Ni19, X8Ni9, G-NiMo16Cr Alloy C4, Hastelloy C276, A494CW-12MW, A743 / A744CW-12M</p>																							
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WELDING POSITIONS																								
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>Cr</td><td>Ni</td><td>Mo</td><td>Fe</td><td>W</td></tr><tr><td>0.01</td><td>0.1</td><td>0.8</td><td>15.5</td><td>60</td><td>16</td><td>5.5</td><td>3.2</td></tr></table>								C	Si	Mn	Cr	Ni	Mo	Fe	W	0.01	0.1	0.8	15.5	60	16	5.5	3.2
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MECHANICAL PROPERTIES	<table><thead><tr><th>Heat Treatment</th><th>R_{P0.2} (MPa)</th><th>R_m (MPa)</th><th>A5 (%)</th><th>Hardness</th></tr></thead><tbody><tr><td>As Welded</td><td>500</td><td>760</td><td>29</td><td>HRc</td></tr></tbody></table>								Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness	As Welded	500	760	29	HRc						
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As Welded	500	760	29	HRc																				
REDRYING	300°C / 2 hr																							
GAS ACC. EN ISO 14175																								



CEWELD E Alloy C-276

E ALLOY C-276 2,4 X 229MM

Packaging	KG/unit	EanCode
Can	2,27	8720663420466

E ALLOY C-276 3,2 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663420473

E ALLOY C-276 4,0 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663420480